

Work Order ID **86335**

June-27-12 1:30:29 PM

Up Now
86335

Page 1

Item ID: D3889-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Panel, Floor
 Start Date: 6/27/12 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 6/27/12 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr					(2)			
D3889	A								

100		0.00							
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100 _____ **B12-6-27**

Waterjet Memo 0.00

FLOW CNC Waterjet 1-Cut as per Dwg D3889-1

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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110 _____ **B12-6-27**

QC Memo 0.00

Quality Control

86335

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N900040100

Setup Start ***NS1***

Stop *NS2*

Start Date: 6/27/12 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 6/27/12 **Req'd Qty:** 2.00 ***?***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

0.00

~~0.00~~

130

130

Small Fab

Small Fab

Memo

Deburr ~~if necessary~~

0.00

0.00

140

140

Packaging

Packaging

Memo

Pick Kit

86335

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 6/27/12 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 6/27/12 **Req'd Qty:** 2.00 ***2***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

0.00

150

0.00

Small Fab

Memo

0.00

Small Fab

I- Bond gasket to smooth side of panel as per dwg
A/R 3M 1300 adhesive Batch: 120904

A/R 3M 1300 adhesive Batch: 120904

160

0.00

160

0,00

QC

Memo

Quality Control

QC5- Inspect part completeness to step on W/O

Identify as per dwg & Stock Location:_____

0.00

170

0.00

Packaging

Memo

Packaging

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/6/28
MF
12-06-27

Picklist Print

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Page 1

Work Order ID: 86335

Parent Item: D3889-041

Parent Item Name: Panel, Floor

Start Date: 6/27/12

Required Date: 6/27/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04 GE PLASTICS LEXAN SHEET		Purchased	No			100	sf	1,654.1064	8.1925	17.247368	18.		

1812-6-27

Location Loc Qty Loc Code

MAT018 1503

121803 1503

MAT019 151.1064

119937 151.1064

D3889-3

Gasket

Manufactured No

140 Each 3.0000

1 2

119937

(2)

(2) FF 12-06-27

Location Loc Qty Loc Code

ST 2

77555 2

ST242 1

81017 1

2



DART AEROSPACE LTD		Work Order:	86355
Description: Panel		Part Number:	D3889-1
Inspection Dwg: D3889	Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

<input checked="" type="checkbox"/>	First Article	<input type="checkbox"/>	Prototype
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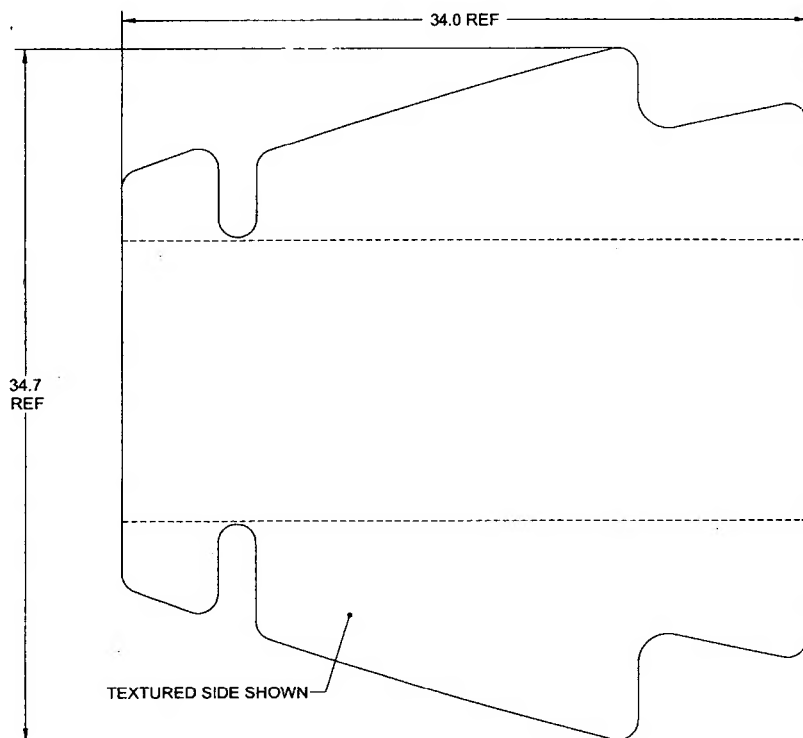
[illegible]

Measured by: <u>B</u>	Audited by: <u>J</u>	Prototype Approval: <u>N/A</u>
Date: <u>12-6-22</u>	Date: <u>12/6/22</u>	Date: <u>N/A</u>

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue P/O D3889-041	KJ 	

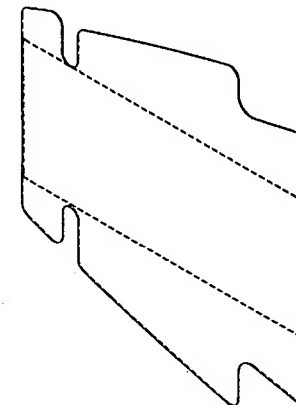
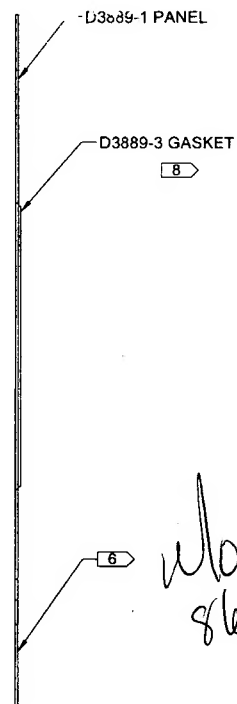
PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3889-041	PANEL, FLOOR
2	1	D3889-1	PANEL
3	1	D3889-3	GASKET
4	A/R	3M 1300	ADHESIVE

**D3889-041 PANEL, FLOOR**

NOTES:

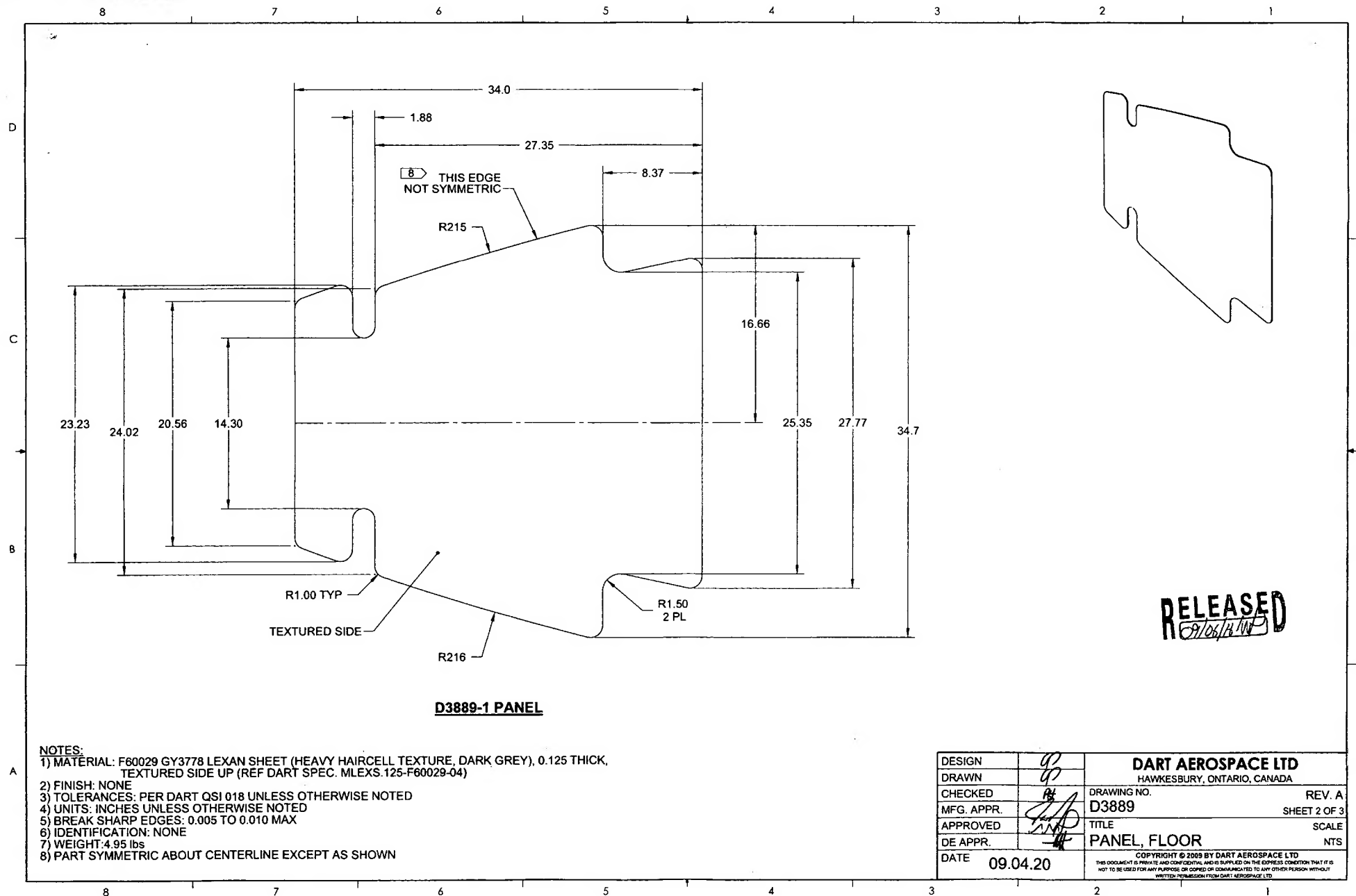
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3889-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 5.13 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.



A	NEW ISSUE	CP	09.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.04.20		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWING NO. D3889	SHEET 1 OF 3	
TITLE PANEL, FLOOR	SCALE NTS	
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RELEASED
9/6/16 N/P



D3889-3 GASKET

NOTES:

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3889	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		PANEL, FLOOR	NTS
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01/06/16 NW

